

Work Order ID 64455

Monday, December 06, 2010 10:21:56 AM



Page 1

Item ID: D3608-1

Accept



Setup

Start



Revision ID:

Item Name: Lower Doubler

Stop



Start Date: 12/6/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: MFDate: 10-12-06 Tooling: _____ Date: _____

Run

Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3608	C

100



FLOW WATER JET

Waterjet

Memo

0.00

10-12-8

FLOW CNC Waterjet

304 . 40

1-Cut as per Dwg D3608

Dwg Rev: CProg Rev: C

2-Deburr if necessary

(4)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

10-12-8

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

10-12-06

(xu)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64455

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Start



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Item Name: Lower Doubler

Stop



Start Date: 12/6/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: 175Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

10/12/8

SF4

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/12/09

MF

10-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, December 06, 2010 10:22:01 AM

Page 1

Work Order ID: 64455



Parent Item: D3608-1



Parent Item Name: Lower Doubler

Start Date: 12/6/2010

Required Date: 12/13/2010

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A New Issue 07-03-26 JLM
IPP Rev:B 08-10-15 preliminary issue DD verified by:EC
IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC IPP
Rev:D 10.02.16 rev.B as per dwg DD verified by:EC IPP Rev:E
10.11.17 as per PC1 dwg DD verified by:EC IPP Rev:F 10.11.29 as
per revC dwg DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	60.1900	0.7392	3.112421			

304/316 .040 Sheet



HB 10-12-8

Location	Loc Qty	Loc Code
MAT	56.6	
115762	10.2	
115953	46.4	115953
MAT20	3.59	
113062	1.398	
115440	2.192	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	64455
Description: LOWER Doubler	Part Number:	D3608-1
Inspection Dwg: D3608-1 Rev: C		Page 1 of 1

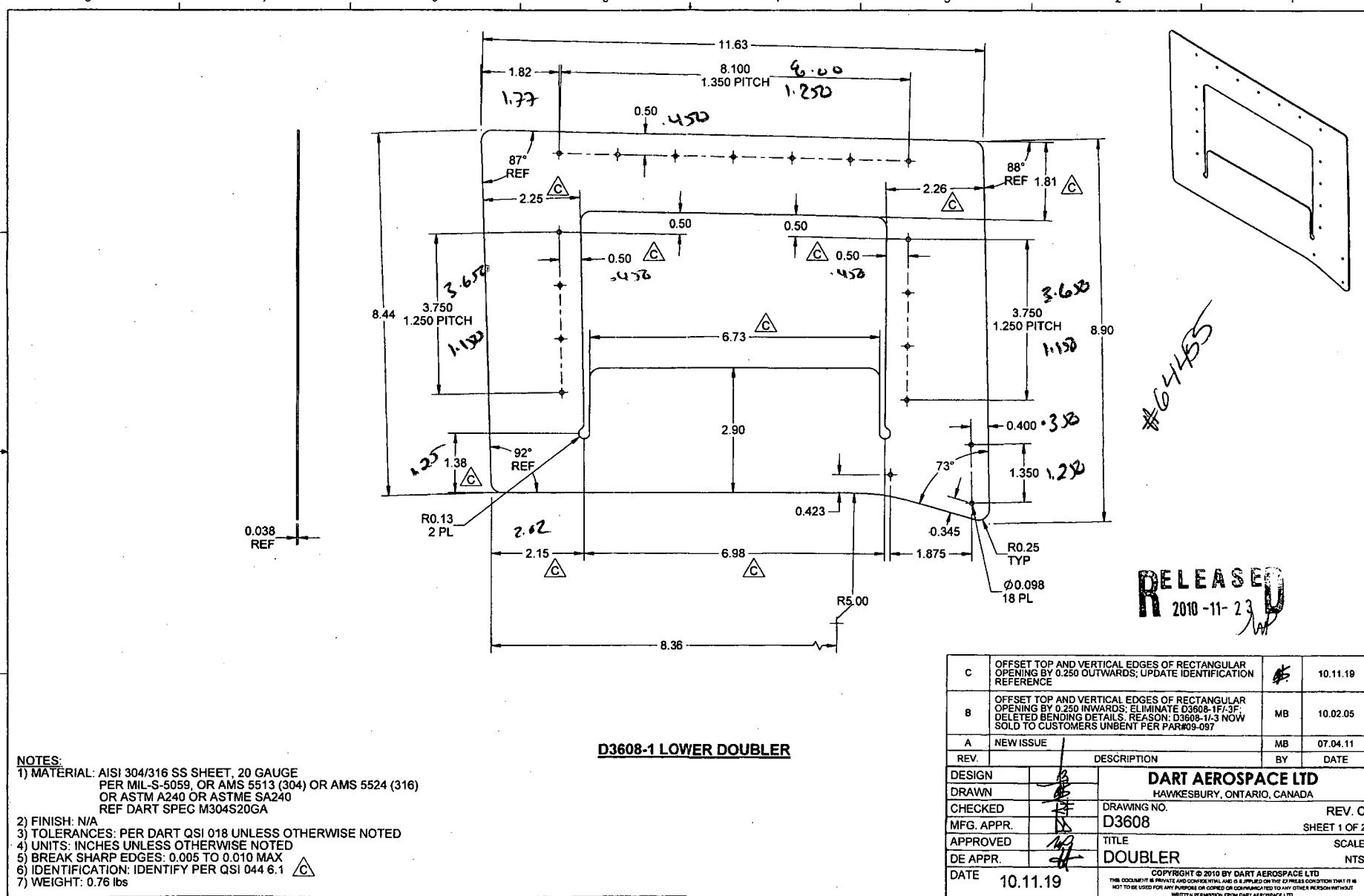
FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Φ .098	+.004 -.001	.100	✗		✓ HB02	
1.82	+.000 -.000	1.805	✗		✓	
.50	+.030 -.030	.503	✗		✓	
11.63	+.030 -.030	11.621	✗		✓ PRO HB02	
8.100	+.010 -.010	8.099	✗		✓ PRO HB02	
1.350	+.010 -.010	1.349	✗		✓	
2.26	+.030 -.030	2.263	✗		✓	
1.81	+.030 -.030	1.816	✗		✓	
3.750	+.010 -.010	3.749	✗		✓	
1.250	+.010 -.010	1.249	✗		✓	
8.90	+.030 -.030	8.888	✗		✓ PRO HB02	
.400	+.010 -.010	.401	✗		✓	
1.350	+.010 -.010	1.348	✗		✓	
.345	+.010 -.010	.341	✗		✓	
1.875	+.010 -.010	1.878	✗		✓	
.423	+.010 -.010	.421	✗		✓	
6.98	+.030 -.030	6.985	✗		✓	
6.73	+.030 -.030	6.731	✗		✓	
2.90	+.030 -.030	2.906	✗		✓	
2.15	+.030 -.030	2.160	✗		✓	
8.144	+.030 -.030	8.1430	✗		✓ PRO HB02	
2.28	+.030 -.030	2.248	✗		✓	
1.36	+.030 -.030	1.373	✗		✓	
.040	+.010 -.010	.037	✗		✓	

Measured by: <u>BS</u>	Audited by: <u>S</u>	Prototype Approval:
Date: 10-12-08	Date: 10/12/08	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



C	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 OUTWARDS; UPDATE IDENTIFICATION REFERENCE	10.11.19
B	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 INWARDS; ELIMINATE D3608-1F7-3F7 DELETED BENDING DETAILS. REASON: D3608-1-3 NOW SOLD TO CUSTOMERS UNBENT PER PAR#09-097	10.02.05
A	NEW ISSUE	07.04.11
REV.	DESCRIPTION	DATE
DESIGN	<i>10</i>	DART AEROSPACE LTD
DRAWN	<i>10</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>10</i>	DRAWING NO.
MFG. APPR.	<i>10</i>	REV. C
APPROVED	<i>10</i>	D3608
DE APPR.	<i>10</i>	SHEET 1 OF 2
DATE	10.11.19	TITLE DOUBLER SCALE NTS

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